

Work Order ID 81783

81783

Page 1

March-19-12 1:25:15 PM

Item ID: D206-642-311BL

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 19/03/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/19 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-642	Rev N

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

[Handwritten signature] MLJ 12-5-2 *[Handwritten signature]*
12-05-09

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

1 12/05/08 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

[Handwritten signature]
12 05 09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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N900040100

Setup Start ***NS1***

Revision ID:

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Item Name: Skidtube LH

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311								
	Location: _____								
	PPP Rev: <u>F</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

PPP 81776

(K)

SP

12-5-9.

12/5/10

ME

12-05-09.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID: 81783

81783

Parent Item: D206-642-311BL

*D206-642-311RI *

Parent Item Name: Skidtube LH

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:J05.10.11Added D3429-1 per CHG004KJ/CP/JLM/EC
 IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
 IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M
 as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341

Manufactured

No

110

Each

3.0000

1

1

D206-642-341

Replacement Skidtube

**

B81776

Location

Loc Qty

Loc Code

FG081

1

57156

0

57160

0

57161

0

69950

1

FG082

2

36550

1

69952

1

D206-648-013

Manufactured

No

110

Each

25.0000

1

D206-648-013

GHW Modification

**

JB 12/05/08

Location

Loc Qty

Loc Code

FG

5

78875

5

FG120

16

65455

0

66633

0

81332

16

FG125

4

78874

4

81332

S m c

ATTN: D3414-041 - BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 81783

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81783

*D206-642-311RI *

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2932-1
D2932-1
Saddle LH Out, 206

Manufactured No

110 Each

18.0000

1 1 ✓
**

JB

Location

Loc Qty

Loc Code

ST421

6

79223

6

ST428

12

73466

2

75096

6

78968

4

79223 .5 u c

BLUE

D2933-1

D2933-1

Saddle LH In, 206

Manufactured No

110 Each

7.0000

1 1 ✓
**

81803 JB .5 u c

Location

Loc Qty

Loc Code

ST421

6

79226

6

ST428

1

76191

1

BLUE

D2938-1

D2938-1

Saddle LH Out, 206

Manufactured No

110 Each

14.0000

1 1 ✓
**

JB 12/05/08

Location

Loc Qty

Loc Code

ST421

6

79228

6

ST428A

8

74605

3

75098

5

79228 .5 u c

BLUE

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 81783

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81783

*D206-642-311BL *

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

hhf D2939-1
D2939-1
Saddle LH In, 206

Manufactured No

110 Each

8.0000

1

1

**

JB

Location

Loc Qty

Loc Code

ST421

6

79230

6

ST428A

2

75099

2

79230 suc

mm BLUE
AN3-41A
AN3-41A
Bolt

Purchased No

110 Each

467.0000

8

8

**

JB

Location

Loc Qty

Loc Code

ST335

267

120644

267

ST354

200

120498

200

120498 suc

mm D2652
D2652
Bushing

Manufactured No

110 Each

692.0000

16

16

**

81952 JB 12/05/08 suc

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

648

73834

15

73836

36

76134

1

76136

55

77134

400

77136

141

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 81783

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81783

*D206-642-311BI *

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

3,027.000

8

8

✓

MS21042I 3

Nut

**

121349 JB

Suc

Location

Loc Qty

Loc Code

ST300

3027

117441

16

117885

32

118451

5

118927

3

119017

2798

119075

173

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8

8

✓

AN960.ID10

Washer

AN5-10A

Purchased

No

110

Each

394.0000

4

4

✓

AN5-10A

Bolt

**

121243 JB

Suc

Location

Loc Qty

Loc Code

ST337

394

118191

80

120630

50

120717

50

120770

214

AN5-11A

Purchased

No

110

Each

749.0000

4

4

✓

AN5-11A

Bolt

**

120770

JB

12/05/02

Location

Loc Qty

Loc Code

ST337

749

118191

13

119512

736

119512

Suc

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 81783

81783

Parent Item: D206-642-311BL

*D206-642-311BL *

Parent Item Name: Skidtube LH

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN960ID516

NAS1149D0563J

Purchased

No

110

Each

0.0000

AN960.ID516

Washer

AN4-6A

Purchased

No

110

Each

1,637.000

AN4-6A

Bolt

**

**

119546 JB Sur

12 JB

Location

Loc Qty

Loc Code

ST356

1637

119017

1637

110

Each

14.0000

AN960ID416

NAS1149D0463J

Purchased

No

AN960.ID416

Washer

**

11907 Sur

121255 JB Sur

Location

Loc Qty

Loc Code

ST351

14

116289

14

110

Each

5,507.000

MS21042L4

Purchased

No

MS21042L4

Nut

**

12 JB 12/05/02

Location

Loc Qty

Loc Code

ST300

5507

117441

51

117601

157

118451

133

119017

200

119075

2966

121011

2000

121011 Sur

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81783

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81783

***D206-642-311BL ***

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110

Each

43.0000

1

✓

D3407-043

Tow Ring

**

JB

Location

Loc Qty

Loc Code

ST420

16

79232

16

79232 S u c

ST463

26

68339

2

74519

9

78841

15

ST464

1

68339

0

71040

1

BLUE

D3456-1

Manufactured No

110

Each

82.0000

1

1

D3456-1

Washer

**

81876 JB 12/05/02
S u c

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

12

77486

12

ST044

63

66848

3

71165

2

73493

8

80252

50

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 81783

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81783

***D206-642-311BL ***

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3457-1
Washer

Manufactured No

110 Each

59.0000

2 2 ✓

**

81977 JB
S u K

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

49

67779

1

76231

7

78801

41

MS21043-4
Nut

Purchased No

110 Each

1,119.0000

1 1 ✓

**

121162 JB S u K

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1079

119546

370

120308

709

AN4C5A
BOLT

Purchased No

110 Each

268.0000

1 1 ✓

**

JB

Location

Loc Qty

Loc Code

ST355

268

112243

168

119017

100

AN960C416
washer

NAS1149C0463 R

Purchased No

110 Each

0.0000

1 1 ✓

**

119017 JB 12/05/02
S u K

March-19-12 1:25:19 PM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 81783

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81783

***D206-642-311BL ***

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3413-1
Ring

Manufactured No

110 Each

78.0000

**

Location

Loc Qty

Loc Code

ST420

21

70773

1

79233

20

ST464

57

76754

33

77940

2

80224

22

79233

BLUE

D2712

D2712

Set Screw

Manufactured No

110 Each

802.0000

**

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

500

79585

500

ST021

252

76065

252

79585

D2934

D2934

Saddle Spacer

Manufactured No

110 Each

88.0000

**

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

82

74883

28

78802

54

78802

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 81783

81783

Parent Item: D206-642-311BL

*D206-642-311BL *

Parent Item Name: Skidtube LH

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

116.0000

2

2

✓

**

D2935

Saddle Spacer

JB 12/05/02

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

110

74882

26

78807

84

78807 S-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-347	WEARSHOE KIT (REPLACES -343)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D3535-11	WEARSHOE (REPLACES D2656-11)
22B					1	1				D3536-11	GASKET
23A					1	1				D3535-23	WEARSHOE (REPLACES D2656-23)
23B					1	1				D3536-23	GASKET
24A					1	1				D3535-35	WEARSHOE (REPLACES D2656-35)
24B					1	1				D3536-35	GASKET
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1	1	1						D3456-1	WASHER
32	1	1	1	1						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET-SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN960C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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